

Date: Thursday, 05/02/2009 3:29:43 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BIPOD MOUNT ASS'Y
Job Number : 45525	
Estimate Number : 13184	
P.O. Number :	Part Number : D3685041
This Issue : 05/02/2009 S.O. No. :	Drawing Number : D3685 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 45216	Material :
Written By :	Due Date : 10/02/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09 02 06</u>	
Comment : : Est Rev:A new issue 08-02-12 DD verified by:LL : Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC : Est Rev:C Added sealant note as per Rev C 09-01-20 JLM : Verified By:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2.0	D36873	MOUNT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 MOUNT
 batch 45299

sq

3.0	D3684047	FWD LEG ASS'Y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 FWD LEG ASS'Y
 batch B45600

090209

4.0	D3684049	AFT LEG ASS'Y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 AFT LEG ASS'Y
 batch B45601

090209

5.0	D36921	SPACER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 SPACER
 batch B44689

9/2/06

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BIPOD MOUNT ASS'Y

Job Number: 45525

Part Number: D3685041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3C12A

Bolts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolts

batch

M110584

54

7.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch

M110023

9/2/16

54

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685

M110658

090209

2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3685

090209

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/09

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

888 45525

09/02/10

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/10

Job Completion



09/02/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

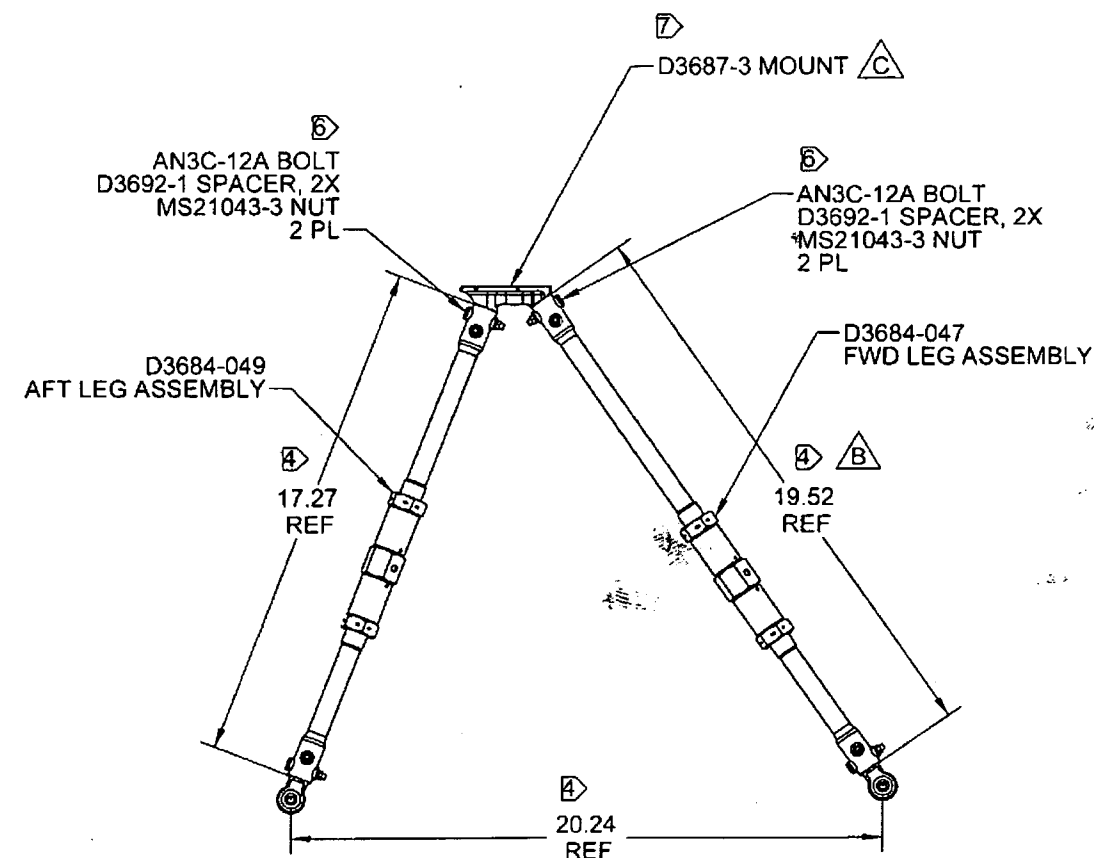
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. G
MFG. APPR.	RF	D3685	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BIPOD MOUNT ASSEMBLY	UNTS
DATE	08.12.15	THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NO. 45525

